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D2344**Job Sheet 192935****Part No:** D2344**Job Qty:** 12 pcs**Part Name:** Deck Plate Aft**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/4/19**Job Tracking No:****Due Date:** 4/26/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV F IPP Rev:D 00.06.26 Removed P/O for powder coat EC IPP Rev:E 07-07-04 Asper Rev F JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		4/26/19	0.11	1.94	Waterjet - Flow		2019/04/29
110	QC 2	12 pcs		4/26/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		2019/04/29
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

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120 QC 8	12 pcs	4/26/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS APR 30 2019 40
				QC 8 - 52	9-89
				QC 8 - 23	DAS
130 Small Fab - 2 - B4B	12 pcs	4/26/19	0.00 1.59	Small Fab - 1 - B4B	58 MAY 01 2019 10
				Small Fab - 2 - B4B	9-89
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
140 QC 5	12 pcs	4/26/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS MAY 01 2019 40
150 Handfinish - 1-1 Chemical-B4B	12 pcs	4/26/19	0.00 0.66	Handfinish - 1 - 1 - B4B	9-89
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	

				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	DR 19/05/01
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
155 QC 7	12 pcs	4/26/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	BL 19-5-7.
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
160 Powdercoat - 4 Black Sand - B4B M135940.	12 pcs	4/26/19	0.00 0.43	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	BL 19-5-7.
START: 8:45 QUT 300° FINISH 9:15.				Plex 4/4/19 10:09 AM Dart.lajeunesse.marie	

				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
170 QC 3	12 pcs	4/26/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
180 Packaging 3-1 - Stock - B4B	12 pcs	4/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 -	

MAY 07 2019
DAS
40
9-89

				B4B	
				Packaging 3 - 27 - B4B	MAY 07 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	12 pcs	4/26/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	MAY 08 2019

Part Op 100 - 1-Cut as per dwg prog rev: D dwg rev: D

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Small Fab) 1-Deburr sharp edges 2-Countersink holes per Dwg D2344

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

155 - (QC7-Inspect Chemical Conversion Coat)

160 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	8.9400 sf (.745 ea)	100-Waterjet - Flow - 1	5146235

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	9	101	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Litter Deck Plate Kit (350)	6.223Inches $\pm$ 0.010	6.233 6.213		
2	Litter Deck Plate Kit (350)	5.598Inches $\pm$ 0.010	5.608 5.588		
3	Litter Deck Plate Kit (350)	4.869Inches $\pm$ 0.010	4.879 4.859		
4	Litter Deck Plate Kit (350)	3.889Inches $\pm$ 0.010	3.899 3.879		
5	Litter Deck Plate Kit (350)	3.096Inches $\pm$ 0.010	3.106 3.086		
6	Litter Deck Plate Kit (350)	2.891Inches $\pm$ 0.010	2.901 2.881		
7	Litter Deck Plate Kit (350)	16.973Inches $\pm$ 0.010	16.983 16.963		
8	Litter Deck Plate Kit (350)	0.450Inches $\pm$ 0.010	0.460 0.440		
9	Litter Deck Plate Kit (350)	4.423Inches $\pm$ 0.010	4.433 4.413		
10	Litter Deck Plate Kit (350)	4.723Inches $\pm$ 0.010	4.733 4.713		
11	Litter Deck Plate Kit (350)	1.202Inches $\pm$ 0.010	1.212 1.192		
12	Litter Deck Plate Kit (350)	5.869Inches $\pm$ 0.010	5.879 5.859		
13	Litter Deck Plate Kit (350)	4.654Inches $\pm$ 0.010	4.664 4.644		
14	Litter Deck Plate Kit (350)	0.656Inches $\pm$ 0.005 - 0.000	0.661 0.656	Diameter	
15	Litter Deck Plate Kit (350)	1.888Inches $\pm$ 0.010	1.898 1.878		
16	Litter Deck Plate Kit (350)	2.285Inches $\pm$ 0.010	2.295 2.275		
17	Litter Deck Plate Kit (350)	2.683Inches $\pm$ 0.010	2.693 2.673		
18	Litter Deck Plate Kit (350)	0.171Inches $\pm$ 0.005 - 0.000	0.176 0.171	Diameter	
19	Litter Deck Plate Kit (350)	3.491Inches $\pm$ 0.010	3.501 3.481		
20	Litter Deck Plate Kit (350)	0.191Inches $\pm$ 0.005 - 0.000	0.196 0.191	Diameter	
21	Litter Deck Plate Kit (350)	3.123Inches $\pm$ 0.010	3.133 3.113		
22	Litter Deck Plate Kit (350)	1.975Inches $\pm$ 0.010	1.985 1.965		
23	Litter Deck Plate Kit (350)	0.128Inches $\pm$ 0.005 - 0.001	0.133 0.127	Diameter	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S176517



Part: D2344

Job No: 192935

Serial No/Batch: S176517

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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